

Open

Date: Wednesday, 11/21/2007 12:47:40 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	35917		Part Number	D2573		
Estimate Number	10533		Drawing Number	D2573 REV E		
P.O. Number	N/A		Project Number	N/A		
This Issue	11/21/2007	S.O. No.	N/A	Drawing Revision	E	
Prsht Rev.	NC	Type	MACHINED PARTS	Material	N/A	
First Issue	N/A			Due Date	1/15/2008	
Previous Run	34839		Qty:	12	Um:	Each
Written By			Comment	Est: I AS Per RevE 06-01-27 JLM		
Checked & Approved By	JL 07.11.2					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: B31389			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 35917 Double check by: JL 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/12/18 20	1	Employee placed the block 0.050" instead on 0.005", resulting in the snidle edges being too thin. R.C: Human error	<u>JP</u> <u>01/12/18</u>	Scrap & destroy. Replace Qty 1 <u>B 31389</u>	S.F 01/12/17	<u>JP</u> <u>01/12/18</u>	<u>JP</u> <u>01/12/18</u>	<u>JP</u> <u>01/12/18</u>
01/12/20	2	(Qty 1) part gouged during tumbling	<u>JP</u> <u>01/12/20</u> <u>08/12/20</u>	SCRAP destroy and <u>Rep</u>	S.F 01/12/17	<u>JP</u> <u>01/12/20</u>	<u>JP</u> <u>01/12/20</u>	<u>JP</u> <u>01/12/20</u>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number: 35917		Part Number: D2573
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: SECOND CHECK		SD 08/01/03
7.0	POWDER COATING	POWDER COATING 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		BR 08-01-04
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: POWDER COATING ★ Powder Coat **SANDTEX GREEN** ★ (Ref: 4.3.5.1) as per QSI 005 4.3		M 102316 BK 08-01-08
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		8/1/09 SP 08/01/09
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		10 08/01/11
Job Completion 		U 28-

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	35917
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	-DT8682	.439	.440	0.441	0.441		
B	1.745	1.755		1.750	1.748	1.749	1.750		
C	3.495	3.505		3.500	3.500	3.499	3.500		
D	1.745	1.755		1.750	1.748	1.749	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		.501	.502	0.503	0.501		
G	0.257	0.262	-DT8683	.258	.259	.258	.258		
H	0.375	0.380	-DT8684	.377	.375	.375	.375		
I	0.490	0.510		.505	.505	.507	.507		
J	1.174	1.184		1.179	1.180	1.180	1.180		
K	0.558	0.578		.573	.570	.569	.569		
L	1.174	1.184		1.179	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.123	4.123		
P	0.115	0.135		.126	.124	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.259	.249	.250		
S	0.115	0.135		.122	.121	.122	.120		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.233	3.230	3.234	3.232		
V	0.230	0.250		.243	.243	.240	.235		
W	0.115	0.135		.123	.126	.122	.124		
X	0.308	0.313		.310	0.310	0.310	0.310		
Y	0.760	0.765		.760	0.760	0.766	0.760		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.627	0.631	0.634		
AC	0.053	0.073		.067	.063	0.063	0.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.513	1.513		
AF	0.115	0.135		.125	.127	.127	.128		
AG	0.240	0.280		.260	.265	.265	.265		
AH	0.240	0.260		.251	.253	.250	.250		
AI	2.000	2.020		2.000	2.000	2.003	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	8F	Audited by:	SD
Date:	07/12/15	Date:	08/01/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

DART AEROSPACE LTD				Work Order:	35917
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505	1.9	3.500	3.500	3.500	3.500		
D	1.745	1.755	1.750	1.750	1.750	1.750	1.750		
E	7.990	8.010	8.01	8.000	8.000	7.999	7.998		
F	0.490	0.510		0.505	0.505	0.504	0.502		
G	0.257	0.262	DT8683	.258	.258	0.259	0.259		
H	0.375	0.380	DT8684	.375	.375	0.376	0.376		
I	0.490	0.510		0.505	0.504	0.502	0.502		
J	1.174	1.184		1.180	1.180	1.177	1.177		
K	0.558	0.578		0.571	0.570	0.567	0.569		
L	1.174	1.184		1.180	1.180	1.177	1.177		
M	1.365	1.375		1.370	1.370	1.369	1.369		
N	2.495	2.505		2.501	2.500	2.500	2.498		
O	4.119	4.129		4.124	4.124	4.121	4.123		
P	0.115	0.135		.126	.126	0.126	0.125		
Q	0.115	0.135		0.135	0.130	0.130	0.135		
R	0.240	0.260		.251	.251	0.250	0.247		
S	0.115	0.135		0.121	0.119	0.121	0.121		
T	0.178	0.198		.188	.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.235	0.235	0.234	0.234		
W	0.115	0.135		0.119	0.122	0.124	0.124		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.762	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.365	0.364	0.364		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		0.629	0.631	0.630	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		.250	.250	0.245	0.246		
AE	1.500	1.520		1.511	1.512	1.512	1.512		
AF	0.115	0.135		0.128	0.125	0.128	0.133		
AG	0.240	0.280		.265	.265	0.265	0.260		
AH	0.240	0.260		0.245	0.248	0.247	0.246		
AI	2.000	2.020		2.002	2.001	2.001	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	8.F	10mf	Audited by:	SD
Date:	07/12/17	07/12/19	Date:	08/01/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

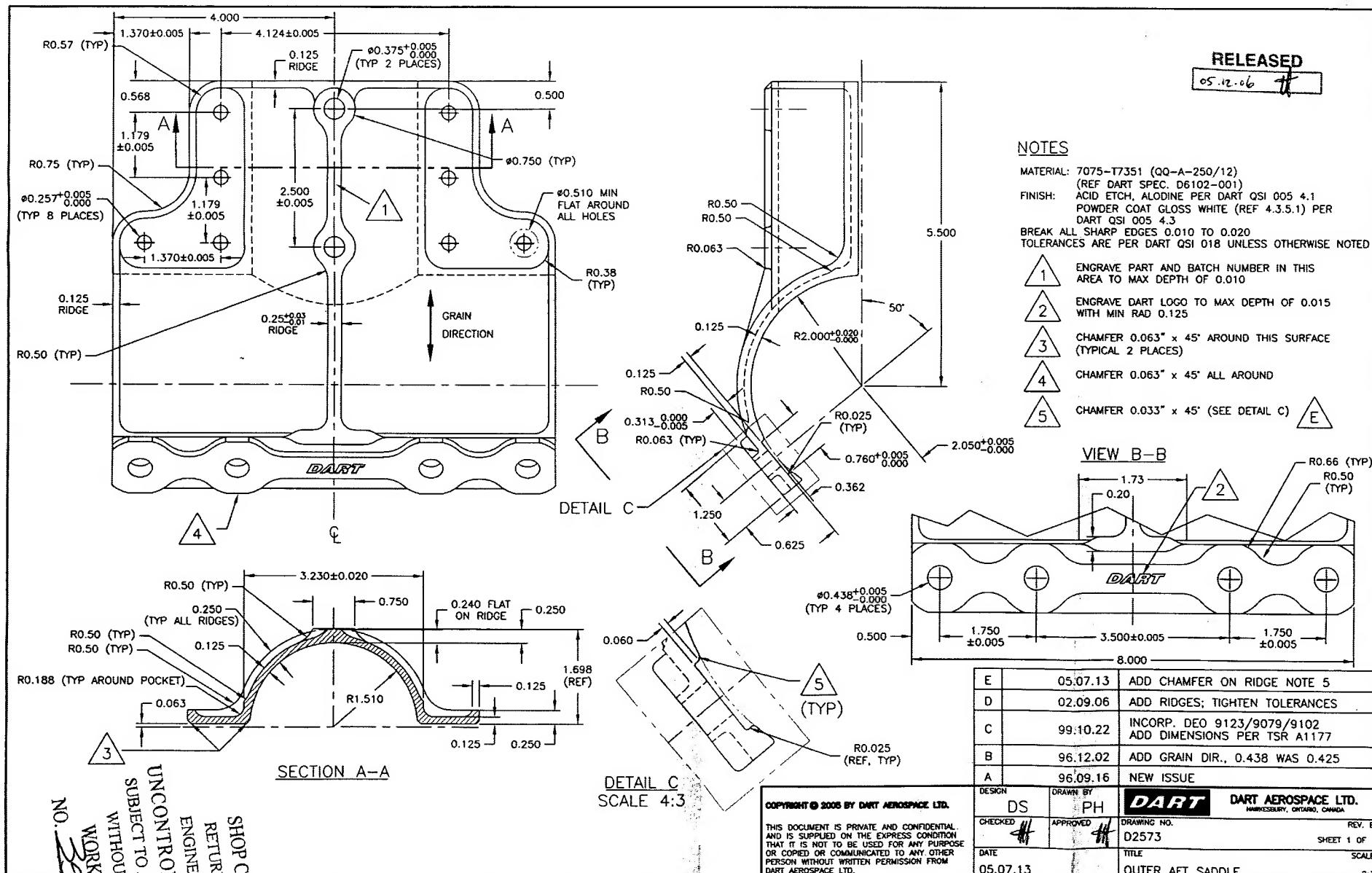
DART AEROSPACE LTD				Work Order:	35917
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
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B	1.745	1.755		1.756	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.756	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.998	7.998		
F	0.490	0.510		0.503	.501	.501	.500		
G	0.257	0.262	DT8683	0.258	0.258	0.259	.258		
H	0.375	0.380	DT8684	0.377	0.377	0.376	.375		
I	0.490	0.510		0.501	0.500	0.502	.508		
J	1.174	1.184		1.177	1.177	1.177	1.172		
K	0.558	0.578		0.568	0.568	0.569	0.569		
L	1.174	1.184		1.172	1.172	1.172	1.170		
M	1.365	1.375		1.367	1.367	1.367	1.367		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.123	4.123	4.124		
P	0.115	0.135		0.126	0.125	0.125	.125		
Q	0.115	0.135		0.135	0.135	0.135	.135		
R	0.240	0.260		0.249	0.249	0.248	.248		
S	0.115	0.135		0.121	0.122	0.123	.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.233		
V	0.230	0.250		0.236	0.238	0.238	.238		
W	0.115	0.135		0.119	0.122	0.121	.120		
X	0.308	0.313		.310	.312	.312	.310		
Y	0.760	0.765		.760	.762	.762	.762		
Z	0.352	0.372		0.365	.365	.361	.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	.630	.630	.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.246	0.247	.245		
AE	1.500	1.520		1.512	1.512	1.512	1.513		
AF	0.115	0.135		0.126	0.136	0.128	.128		
AG	0.240	0.280		0.260	0.260	0.260	.260		
AH	0.240	0.260		0.248	0.248	0.247	.247		
AI	2.000	2.020		2.001	2.001	2.001	2.003		
AJ	0.023	0.043		.033	.033	.033	.023		
Accept/Reject									

Measured by:	<i>CMR/11.8.1</i>	Audited by:	<i>SD</i>
Date:	<i>07/12/19, 07/12/20</i>	Date:	<i>08/07/03</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>CMR</i>	<i>SD</i>



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